

Work Order ID 76836-1

76836

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November 22, 2011 8:10:06 AM

Item ID: D6101-001

Revision ID:

Item Name: Saddle Billet

Start Date: 11/22/11 Start Qty: 100.00

Required Date: 12/19/11 Req'd Qty: 100.00

Reference:

Approvals: Process Plan:

QC:

Date: 11/11/22

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

NR1

NR2

N9000040100

Setup

Stop

NS1

NS2

Cust Item ID:

Customer:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D6101

Rev B

100

0.00

100

Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O:

a) Description: Alluminum billet

b) 6.00" x 6.250" x 2.00" thick

c) Tolerance on length are +0.030"/-0.000"; E: +/-0.008"

d) Grain direction along 6.00" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

Ensure material certification is attached

11/11/23 100

11/11/24 100

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November 22, 2011 8:10:06 AM

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Start Date: 11/22/11 Start Qty: 100.00

Required Date: 12/19/11 Req'd Qty: 100.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D

amt 11/11/26

600

130

Identify as per dwg & Stock Location: MAT42

0.00

130

Packaging

Memo

0.00

Packaging

amt 11/11/26

600

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

11/11/28

amt

11-11-27

Picklist Print

November 22, 2011 8:10:06 AM

Page 1

Work Order ID: 76836

Parent Item: D6101-001

Parent Item Name: Saddle Billet

Start Date: 11/22/11

Required Date: 12/19/11

Start Qty: 100.00

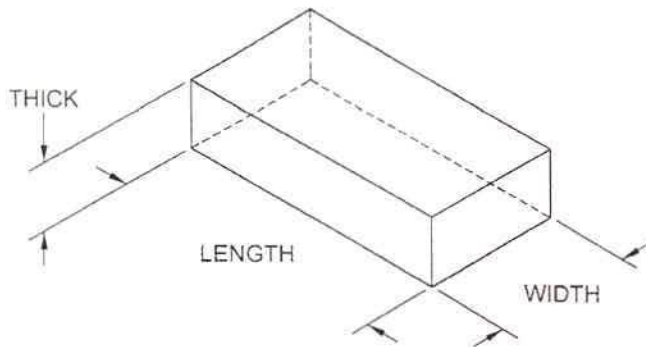
Required Qty: 100.00

Comments: IPP B: 01.05.04New IssueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001P 7075-17351 2X6X6.25		Purchased	No			110	Each	0.0000	1	100			

Perkins

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

B

02 June 22
WB. 76830

RELEASED
09/07/15/W

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15518

Purchase Order Date 11/23/11

PO Print Date 11/23/11

Page Number 2 of 3

Order From :

VC-MET001

METAUX CASTLE
A.M. CASTLE & CO. (CANADA) INC. - BOX B9204 PO BOX 9100
TORONTO, ON M4Y 3A5
CA

Contact Name

Vendor Phone 514 694 9575

Vendor Fax 514 695 3281

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Special Inst:

AS PER DWG D6101 REV. B
B76839
MATERIAL: 7075-T7351 AS PER QQ-A-
250/12
SIZE: 7.750" X 8.250" X 2.50" THICK
GRAIN DIRECTION ALONG 7.750"
LENGTH
TOLERANCE ON ALL DIMENSION ARE
+0.030"/-0.000'

3

D6101-001P

7075-T7351 2X6X6.25

12/19/11

Yes

100.00 Yours ppd

Each

\$45.1000

\$4,510.00

Special Inst:

AS PER DWG D6101 REV. B
B76836
MATERIAL: 7075-T7351 AS PER QQ-A-
250/12
SIZE: 6.00" X 6.250" X 2.00" THICK
GRAIN DIRECTION ALONG 6.00"
LENGTH
TOLERANCE ON ALL DIMENSION ARE
+0.030"/-0.000'

4

D6101-003P

7075-T7351 2X6.25X7.875

12/19/11

Yes

100.00 Yours ppd

Each

\$59.1600

\$5,916.00

Special Inst:

AS PER DWG D6101 REV. B
B76837
MATERIAL: 7075-T7351 AS PER QQ-A-
250/12
SIZE: 7.875" X 6.250" X 2.00" THICK
GRAIN DIRECTION ALONG 7.875"
LENGTH
TOLERANCE ON ALL DIMENSION ARE
+0.030"/-0.000'

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 11/23/11

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP

Page 1 of 1

Shipment No:1057879

Ship From: A. M. Castle & Co. (Canada) Inc. MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 09-NOV-2011	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 1057879-2	

Shipment Details

Final Destination Branch - MON

Order No 1774299	Line No 1	Item No 752237.MO	Description 2.0000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT 2SIDED TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) X 6 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) - ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/12				
Purchase Order No 14899 REPLACEMENT 15318		Part Number YOUR ITEM NUMBER: D6101-001		Ordered Qty 60.00 PCS		Invoice Qty 60 PCS	
Details							
Delivery No. 100852321	Mill	Heat Number 510231A4	Mech Id	PCS 60	Width (IN)	Length (IN)	Shipped Qty(LBS) 464.5

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:

Name:

SHIP TO:

A M CASTLE & CO
3050 SOUTH HYDRAULIC
WICHITA, KS 67216

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

SOLD TO:

AM CASTLE & CO- SOLD TO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

CERTIFIED TEST REPORT

Serial Number

4197294

CUSTOMER PO NUMBER: 55644		WORK PACKAGE:		CUSTOMER PART NUMBER: 6857 AMC A97075-160		SHIP RUN/LOAD: 101822/9		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1099234	LINE ITEM: 4	SHIP DATE: 21-JUN-2010	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: Sawed Plate			
WEIGHT SHIPPED: 7208 LB	QUANTITY: 5 PCS EST.	B/L NUMBER: 2027831	GAUGE: 2.0000 IN		DIAMETER/WIDTH: 48.500 IN		LENGTH: 144.500 IN		

Certified Specifications

AMS 4078/RevG
ASTM B 209/Rev07
BSS 7055/RevA
DPS 4.713/RevAH
MMS 159/RevN

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevS
GAMPS 9101/RevB
PS 21211/RevK

AMS-STD-2154
BAC 5439/RevH
CSTI 006/RevC
GSS16100/RevG/Amd1

Test Code: 4297

Test Results

Lot: 510231A4 Cast 323

Drop 16

Ingot 2

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper T7351	Dir / # Tests LT / 2 (Min:Max)	Ultimate KSI (MPA) 73.1 : 74.1 (504 : 511)	Yield KSI (MPA) 62.7 : 63.6 (432 : 439)	Elongation % 12.5 : 12.7
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(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	41.9 Min	42.0 Max
(MS/M) :	24.3 Min	24.4 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.17	1.6	0.03	2.4	0.20	5.8	0.03	0.01	0.01	TOT 0.05



**KAISER
ALUMINUM**Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586**CERTIFIED TEST REPORT**Serial Number
4197294**ALLOY LIMITS**

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

TEST NOTES

7075-T7351 plate 3.501-4.000" thick, if
ultrasonically inspected, meets requirements of CMMP025 per
SDR CMMP025-KaiserT-3. 7075-T7351 plate 4.001-5.000" thick,
if ultrasonically inspected, meets requirements of CMMP025
per
SDR CMMP025-KaiserT-2.

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER DFARS 225.872-1(a), WAS MANUFACTURED IN THE UNITED STATES OF AMERICA, AND MEETS THE REQUIREMENTS OF DFARS 252.225 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED.

BILL POYNOR, LABORATORIES SUPERVISOR

